

Date: Monday, 04/05/2009 1:44:49 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	REAR OVERHEAD CENTER
Job Number :	47670C		
Estimate Number :	13591		
P.O. Number :		Part Number :	D38233 64
This Issue :	04/05/2009	Drawing Number :	D3823-3
Prsht Rev. :	NC	Project Number :	
First Issue :	//	Drawing Revision :	B
Previous Run :	47312C	Material :	MKYD6185S080P362015
Written By :		Due Date :	11/05/2009
Checked & Approved By :	<u>DD 09/05/09</u>	Qty:	1 Um: Each
Comment :	Est. A New Issue 08/09/17 DL Rev B Dwg. Update 09/02/09 DL verified by:DD		



Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MKYD6185S080P352068	6185 Kydex .080 steel grey
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MP
09/05/25



Comment: Qty.: 11.3747 sf(s)/Unit Total : 11.3747 sf(s)
 6185 Kydex .080"

H 111807

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

BB 111807

09/05/21 X1

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/08/21

X2

4.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3823-3 and folio FTA 032 using tool DT 9110

Dwg. Rev.

BF
B

Folio Rev.

B 09/05/21 X2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 04/05/2009 1:44:49 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR OVERHEAD CENTER

Job Number: 47670C

Part Number: D38233

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/05/21 (x2)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Dh 09/05/21

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

Dh 09/05/21

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

Dh. 09/05/21

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/25 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP47670

POSITIVE RECALL

RECEIVED 09/05/20

AUTH U

DATE 09/05/25

09/05/25

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/26

Job Completion



MF 09-05-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 77670C
Description:	Part Number: 03823-3
Inspection Dwg: 03823-3 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____" N/A				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JB

Date: 09/05/21

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.36	MIN.	0.40"	✓			
0.50	MIN.	0.61"	✓			
0.75	MIN.	0.75"	✓			
0.50	MIN.	0.51"	✓			
0.045"	MIN.	0.054"	✓			
0.055"	MIN.	0.073"	✓			

Measured by: Wh

Date: 09.05.21

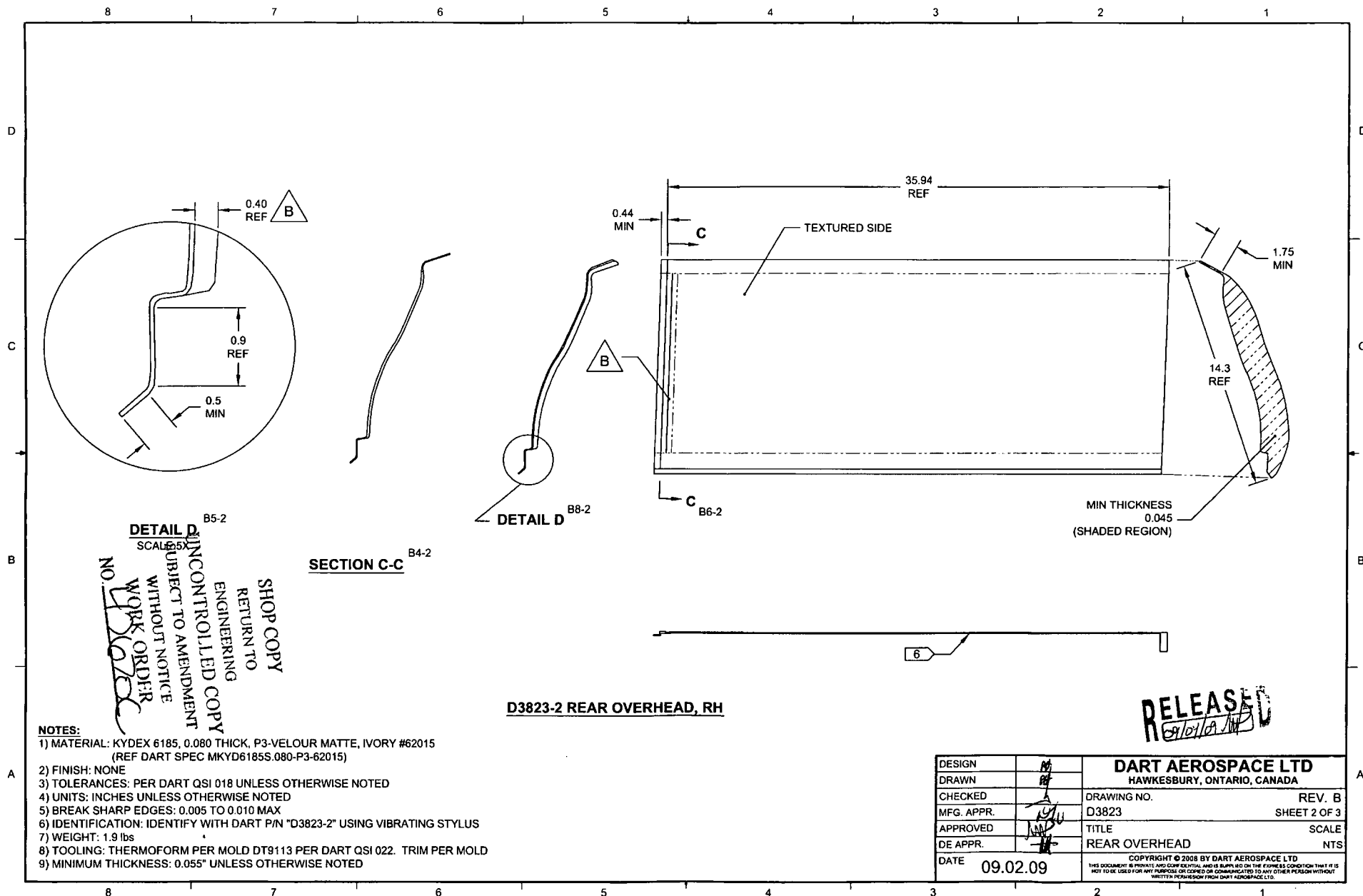
Audited by: [Signature]

Date: 09.05.25

Prototype Approval: _____

Date: _____

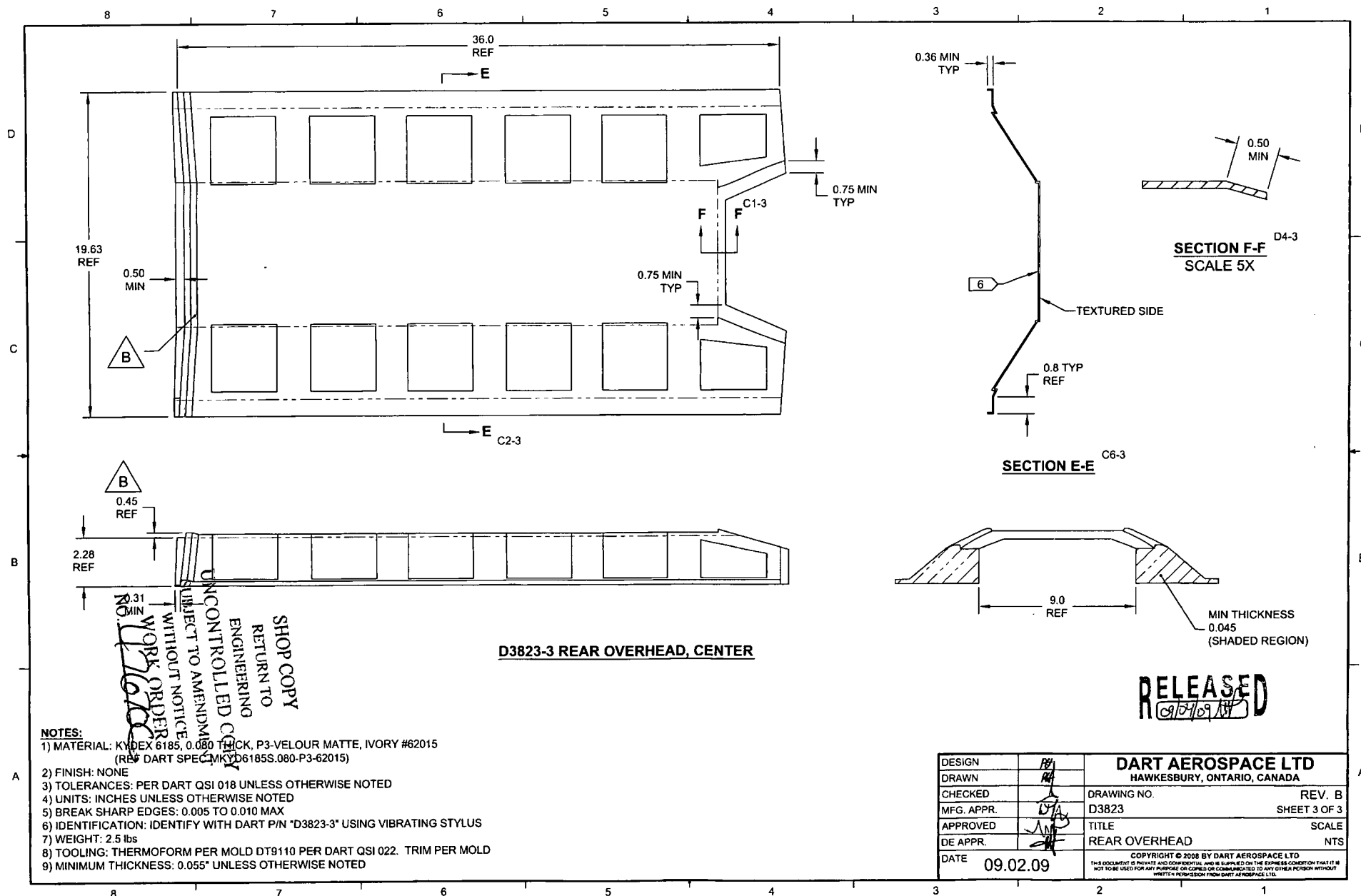
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

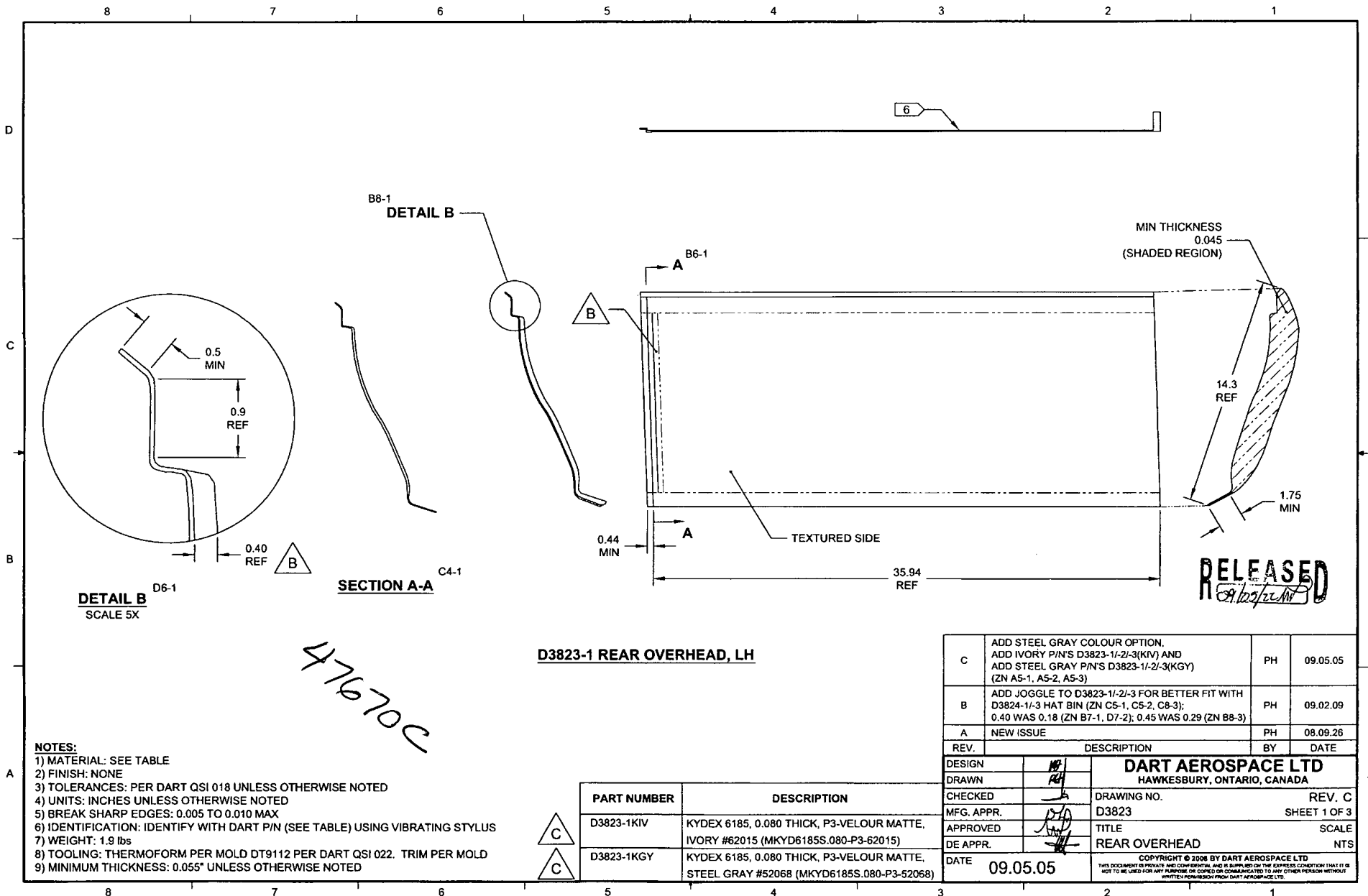


NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
(REF DART SPEC MKYD6185S.080-P3-62015)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3823-2" USING VIBRATING STYLUS
- 7) WEIGHT: 1.9 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9113 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3823	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		REAR OVERHEAD	NTS
DATE	09.02.09	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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47670C

D3823-1 REAR OVERHEAD, LH

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.9 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9112 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3823-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3823-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N'S D3823-1/-2/-3(KIV) AND ADD STEEL GRAY P/N'S D3823-1/-2/-3(KGY) (ZN A5-1, A5-2, A5-3)	PH	09.05.05
B	ADD JOGGLE TO D3823-1/-2/-3 FOR BETTER FIT WITH D3824-1/-3 HAT BIN (ZN C5-1, C5-2, C8-3); 0.40 WAS 0.18 (ZN B7-1, D7-2); 0.45 WAS 0.29 (ZN B8-3)	PH	09.02.09
A	NEW ISSUE	PH	08.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3823
TITLE REAR OVERHEAD
REV. C
SHEET 1 OF 3
SCALE NTS

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